

5/21

quite back to
Receiving when
done step 9-13

Split w/o

DART AEROSPACE LTD

Description: Door Assembly

Dwg: D3296 Rev. A

Work Order:

23199

A

Part Number:

D3296-041

Qty:

to 30 10

Page 1 of 2

Step	Location	Procedure	By	Date	Qty																
1	DC	Issue Traveler Note: To be made in multiples of 10	AP	05/05/09	10																
2	MV	Cut blanks: 17.100" x 5.150" Material: 2024-T3 (QQ-A-250/4) 0.063" thick (M2024T3S.063) Identify for D3296-1 Batch: <u>M16807</u>	JL	05/05/18	30																
3	MV	Cut blanks: 17.100" x 5.150" Material: 2024-T3 (QQ-A-250/4) 0.063" thick (M2024T3S.063) Identify for D3296-3 Batch: <u>M16807</u> <u>M16645</u>	JL	05/05/18	30																
4	MV	Machine as per Folio FA443 and Dwg D3296 Stack of 10 Identify as D3296-1	JL	05/05/18	30																
5	QC2	Inspect parts as they come off the CNC machine	JL	05/05/18	30																
6	QC8	Second check	SD	05/05/18	30																
7	MV	Machine as per Folio FA443 and Dwg D3296 Stack of 10 Identify as D3296-3	JL	05/05/18	30																
8	QC2	Inspect parts as they come off the CNC machine	JL	05/05/18	30																
9	QC8	Second check	SM	05/05/19	30																
10	GA	Deburr D3296-1/-3	FF	05/05/25	30																
11	FP	Chemical Conversion Coat as per QSI 005 4.1	FF	05/06/2	30																
12	QC3	Inspect Chemical Conversion Coat	SB	05/06/14	30																
13	GA	Assemble hinges as per Dwg D3296 Pick: <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>1</td><td>D3161-7</td><td>Hinge</td><td>B 22980 B 23567</td></tr><tr><td>1</td><td>D3161-9</td><td>Hinge</td><td>B 23203</td></tr><tr><td>25</td><td>MS20470AD4-4</td><td>Rivet</td><td>N 15825</td></tr></table>	Qty	Part Number	Description	Batch	1	D3161-7	Hinge	B 22980 B 23567	1	D3161-9	Hinge	B 23203	25	MS20470AD4-4	Rivet	N 15825	SB	05/06/16	10
Qty	Part Number	Description	Batch																		
1	D3161-7	Hinge	B 22980 B 23567																		
1	D3161-9	Hinge	B 23203																		
25	MS20470AD4-4	Rivet	N 15825																		
14	FP	Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3	FC	05/06/22	10																
15	QC3	Inspect Powder Coat	ML	05/06/22	10																

RELEASED
11/21/20

Dart Aerospace

DART AEROSPACE LTD		Work Order:	23199
Description: Door Assembly		Part Number:	D3296-041
Dwg: D3296 Rev. A		Qty:	10
		Page 2 of 2	





Step	Location	Procedure	By	Date	Qty																																												
16	GA	<div>Fabricate & assemble as per Dwg D3296.</div> <div>Pick:</div> <table><thead><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr></thead><tbody><tr><td>1</td><td>D2137</td><td>Decal</td><td>B21425</td></tr><tr><td>1</td><td>D2419</td><td>Handle</td><td>B21426</td></tr><tr><td>1</td><td>D2462-0040</td><td>Seal B 19351</td><td>B22749</td></tr><tr><td>1</td><td>D2462-0053</td><td>Seal</td><td>B22749</td></tr><tr><td>1</td><td>D2462-0245</td><td>Seal</td><td>B22749</td></tr><tr><td>1</td><td>D2728-1</td><td>Decal</td><td>B17991</td></tr><tr><td>1</td><td>D3296-1</td><td>Door Panel</td><td>B23199</td></tr><tr><td>1</td><td>D3296-3</td><td>Door Panel</td><td>B23199</td></tr><tr><td>1</td><td>AN960JD6</td><td>Washer</td><td>H4970</td></tr><tr><td>1</td><td>MS20470AD4-6</td><td>Rivet</td><td>H15924</td></tr></tbody></table>	Qty	Part Number	Description	Batch	1	D2137	Decal	B21425	1	D2419	Handle	B21426	1	D2462-0040	Seal B 19351	B22749	1	D2462-0053	Seal	B22749	1	D2462-0245	Seal	B22749	1	D2728-1	Decal	B17991	1	D3296-1	Door Panel	B23199	1	D3296-3	Door Panel	B23199	1	AN960JD6	Washer	H4970	1	MS20470AD4-6	Rivet	H15924	SA	05/06/23	10
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17	QC5	Inspect work to Step 20	J	05.06.23	10																																												
18	ST	Identify and Stock	Dr	05/06/24	10																																												
19	AC	Cost / part: 34.92	Al	05/06/27	10																																												
20	DC	Close W/O 58.16 Inspect Level 21	HA	05.06.28	10																																												


PTD

Rev	Date	Change	Revised By	Approved
A	04.08.24	New issue	KJ/JLM	
B	04.11.26	Revised Steps 13-17	KJ/JLM	

RELEASED
04/11/27

Work Order:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector

NCR 23199 D3296-041		WORK ORDER NON-CONFORMANCE						
DATE	STEP	Description of NC section A	Initial	Corrective Action Section B	Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector
05-06-23	16	02137 decal applied to wrong side.		Leave decal on and apply Another decal as produg.	SB 05/06/23	 05-06-23		 05-06-23

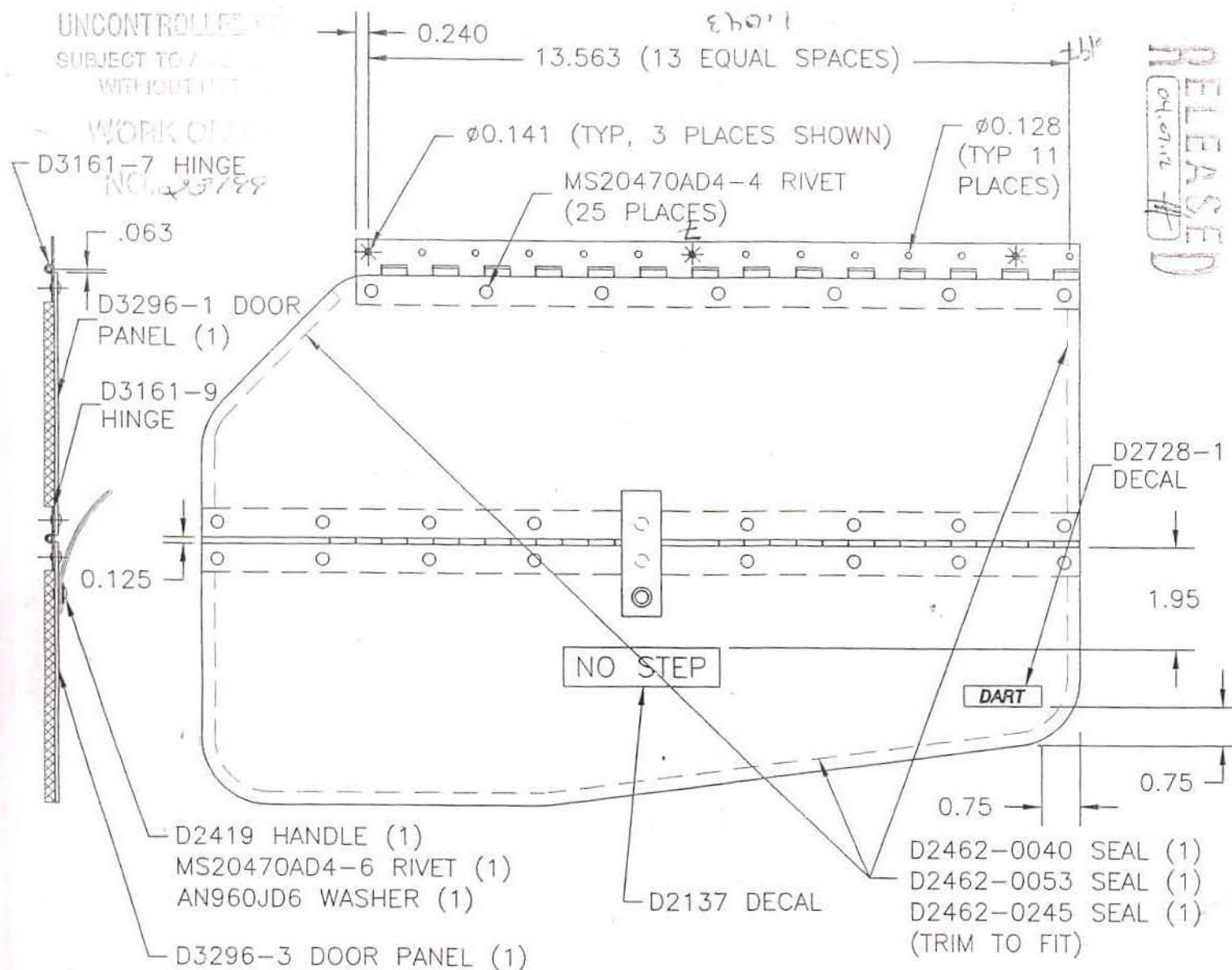
PAR#: N/A Fault Category: N/A DQA:  Date: 05/06/30

NOTE: Date & initial all entries
H:\Admin-QA\ISO\forms\w\oncb.doc

QA: N/C Closed: _____ Date: _____

UNCONTROLLED
SUBJECT TO /
WITHOUT

WORK ON
NO. 23188



D3296-041 DOOR ASSEMBLY

- 1) FOLD AND FASTEN D2419 TO FORM 2.5" LONG HANDLE
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) INSTALL D2137 & D2728-1 DECALS, D2419 HANDLE, AND D2462 SEALS AFTER POWDER COAT
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
04.07.12

DART

GA COPY
ISSUED

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
DATE		D3296
04.06.28		TITLE
A	04.06.28	DOOR ASSEMBLY
		NEW ISSUE
		REV. A
		1 OF 2
		SCALE
		1:3